



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4634-141
Job Sheet 201702



Part No: D4634-141

Job Qty: 1 pcs

Part Name: Fwd, Center Ceiling Replacement Panel Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/9/19

Job Tracking No:

Due Date: 11/15/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4634 REV.H SHEET 7 IPP Rev. A 12/08/09 New Issue DL IPP Rev B 12/11/08 Document release DL
VERIFIED BY:JLM IPP Rev C 13/07/09 Dwg Update DL ver: DD IPP Rev D Dwg Update 13/12/23 DL IPP
REV E Dwg update 14/01/09 DL IPP Rev F Dwg. update 14/02/03 DL IPP Rev G Dwg. Update 15/01/27 DL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	11/15/19		0.00	1.67	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
120	QC 5	1 pcs	11/15/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
130	Packaging 3-1 - Stock - B4B	1 pcs	11/15/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		

Plex 10/30/19 7:44 AM Dart.lajeunesse.marie

				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - SA	1 pcs	11/15/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

DAS
58
JAN 16 2020
9-89

DAS
21
JAN 17 2020
9-89

Part Op 100 - Small Fab (Small Fab) Assemble as per Dwg D4634-141 Bond foam core to inside of panel 3M Scotch Weld 1300
 Descriptions: Batch: 5214697 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II. (see note 8) Batch # 5159491 Expiry Date 03/27/2020 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer (see note 9) Batch: M13896129 May 20
 120 - QC5 (QC5- Inspect part completeness to step on W/O) QC5- Inspect part completeness to step on W/O
 130 - Packaging3 (Identify as per dwg & Stock Location: _____) Identify as per dwg & Stock Location: _____
 140 - QC21 (QC21- Final Inspection - Work Order Release) QC21- Final Inspection - Work Order Release

012735

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
CCR264SS-3-03	Cherry Rivet	4 Ea (4 ea)	100-Small Fab - 1	5180315
D4634-1	Fwd, Center Ceiling Panel	1 pcs (1 ea)	100-Small Fab - 1	5180315
D4636-5	Bracket	1 pcs (1 ea)	100-Small Fab - 1	5180315
D4647-5	Doubler	1 pcs (1 ea)	100-Small Fab - 1	5180315
D4664-5	Spacer	6 pcs (6 ea)	100-Small Fab - 1	5180315
D4712-1	Bracket	1 pcs (1 ea)	100-Small Fab - 1	5180315
D4732-15	Label	1 pcs (1 ea)	100-Small Fab - 1	5180315
D4732-19	Label	1 pcs (1 ea)	100-Small Fab - 1	5180315
D5021-1	Foam, Center Panel, Fwd	1 pcs (1 ea)	100-Small Fab - 1	5180315
MPNY-750S-9-C	Mounting Pad	7 pcs (7 ea)	100-Small Fab - 1	5180315
MS20426AD4-6	Rivet	2 Ea (2 ea)	100-Small Fab - 1	5180315
MS21059L08	Nut	2 Ea (2 ea)	100-Small Fab - 1	5180315

ST321
CA153
ST108
mfoch
mfoch
mfoch
" "
" "
ST370
GA007
ST360

5247183

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	CCR264SS-3-03	4	176	0
	D4634-1	1	1	0
	D4636-5	1	41	0
	D4647-5	1	13	0
	D4664-5	6	7	0
	D4712-1	1	13	0
	D4732-15	1	15	0
	D4732-19	1	22	0
	D5021-1	1	2	0
	MPNY-750S-9-C	7	104	0
	MS20426AD4-6	2	873	0
	MS21059L08	2	139	0
Part Specifications				
Specifications could not be found.				

Plex 10/30/19 7:44 AM Dart.lajeunesse.marie

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____		DISPOSITION				DEPARTMENT/PROCESS																																																																																											
Part No. _____		Rework ☐ Scrap ☐ Use-as-is ☐				Skid-tube ☐ Machining ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐																																																																																					
Date :	Sequence #:	QTY Affected :		MRB (QS1042)																																																																																													
Description Work Order Deviation		Disposition																																																																																															
Root Cause <table border="1"><tr><td>Operator</td><td>☐</td></tr><tr><td>Manufacturing Process</td><td>☐</td></tr><tr><td>Equip/Tooling</td><td>☐</td></tr><tr><td>Handling/Preservation</td><td>☐</td></tr><tr><td>Material</td><td>☐</td></tr><tr><td>Product Improvement</td><td>☐</td></tr><tr><td>Process Improvement</td><td>☐</td></tr><tr><td>Human Factors</td><td>☐</td></tr></table>		Operator	☐	Manufacturing Process	☐	Equip/Tooling	☐	Handling/Preservation	☐	Material	☐	Product Improvement	☐	Process Improvement	☐	Human Factors	☐	FAULT CATEGORY <table border="1"><tr><td>Pressure/Forced</td><td>☐</td><td>Contamination</td><td>☐</td><td>Power Loss/Surge</td><td>☐</td><td>Positioned Wrong</td><td>☐</td></tr><tr><td>Bending</td><td>☐</td><td>Misaligned/off center</td><td>☐</td><td>Folio/Program</td><td>☐</td><td>Outside Tolerance</td><td>☐</td></tr><tr><td>Crushing</td><td>☐</td><td>BOM/Route</td><td>☐</td><td>Grain Direction</td><td>☐</td><td>Drawing</td><td>☐</td></tr><tr><td>Cracks</td><td>☐</td><td>Broken/Damage/Defect</td><td>☐</td><td>Weld</td><td>☐</td><td>Finish</td><td>☐</td></tr><tr><td>Crimp/Kink/Ripple/Wave/Twist</td><td>☐</td><td>Incomplete/Unclear Instructions</td><td>☐</td><td>Wrong Stock Pulled</td><td>☐</td><td>Part Lost/Missing</td><td>☐</td></tr><tr><td>Marks/Chatter</td><td>☐</td><td>Drill Holes</td><td>☐</td><td>Out of Sequence</td><td>☐</td><td>Misread</td><td>☐</td></tr><tr><td>Mislabeled</td><td>☐</td><td>Fit/Function</td><td>☐</td><td>Off-set/Set-up</td><td>☐</td><td></td><td></td></tr><tr><td colspan="8">Other/Details:</td><td colspan="4"></td></tr></table>												Pressure/Forced	☐	Contamination	☐	Power Loss/Surge	☐	Positioned Wrong	☐	Bending	☐	Misaligned/off center	☐	Folio/Program	☐	Outside Tolerance	☐	Crushing	☐	BOM/Route	☐	Grain Direction	☐	Drawing	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Finish	☐	Crimp/Kink/Ripple/Wave/Twist	☐	Incomplete/Unclear Instructions	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐	Marks/Chatter	☐	Drill Holes	☐	Out of Sequence	☐	Misread	☐	Mislabeled	☐	Fit/Function	☐	Off-set/Set-up	☐			Other/Details:											
		Operator	☐																																																																																														
		Manufacturing Process	☐																																																																																														
Equip/Tooling	☐																																																																																																
Handling/Preservation	☐																																																																																																
Material	☐																																																																																																
Product Improvement	☐																																																																																																
Process Improvement	☐																																																																																																
Human Factors	☐																																																																																																
Pressure/Forced	☐	Contamination	☐	Power Loss/Surge	☐	Positioned Wrong	☐																																																																																										
Bending	☐	Misaligned/off center	☐	Folio/Program	☐	Outside Tolerance	☐																																																																																										
Crushing	☐	BOM/Route	☐	Grain Direction	☐	Drawing	☐																																																																																										
Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Finish	☐																																																																																										
Crimp/Kink/Ripple/Wave/Twist	☐	Incomplete/Unclear Instructions	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐																																																																																										
Marks/Chatter	☐	Drill Holes	☐	Out of Sequence	☐	Misread	☐																																																																																										
Mislabeled	☐	Fit/Function	☐	Off-set/Set-up	☐																																																																																												
Other/Details:																																																																																																	
Completed By		Lead hand / Supervisor																																																																																															
		QC / QA Coordinator																																																																																															